

Quick Silver

Work Order ID 51855



Page 1

Tuesday, September 08, 2009 8:40:26 AM

Item ID: D206-642-612QS

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube RH -QUICK SILVER

Start Date: 9/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

U/R

Rev L/ U/R

100

0.00



SprayPaint

Spray Painting

Memo

0.00

1 X D206-642-612 B 32454 CHG 003
REMOVE ALL WEARPLATES AND HARDWARE AND RING (KEEP TO
RE-ASSEMBLE)

SCUFF RING

REMOVE SADDLES FROM KIT AND SCUFF

SCUFF TUBE LIGHTLY TO RE-PAINT IMRON QUICK SILVER B 112614
PER QSI005

APPLY IMRON CLEAR B 112632

ml 09 09 10

110

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

EC 09-09-14

DART			
TRANSPORT CANADA APPROVAL # 09-09			
TEL: 1-613-632-3336	FAX: 1-613-632-4443		
P/N	D206-642-612	CHG	CHG003
DESC	Float Skidtube RH	STC	SH98-4
LCT	B32454	STC	SA00475SE
DATE	Bell 206A/B	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

Work Order ID 51855

Page 3

Tuesday, September 08, 2009 8:40:26 AM

Item ID: D206-642-612QS

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube RH -QUICK SILVER

Start Date: 9/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	8/5/09/14			(X)	4		
160 Packaging Packaging	RE-PACKAGE PER PPP USING NEW B/N, NEW LABELS REQ'D Memo	0.00 0.00	8/5/09/14		REUD CH6003	9/9/14	(X) SP		
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/09/14	(X)		MF 09-09-14

Picklist Print

Page 1

Tuesday, September 08, 2009 8:40:25 AM

Work Order ID: 51855



Parent Item: D206-642-612QS



Parent Item Name: Float Skidtube RH -QUICK SILVER

Start Date: 9/4/2009

Required Date: 9/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D206-642-612RevL		Manufactured	No				Each	10.0000	1.0000			

Float Skidtube RH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	3	
32453	1	
32454	1	
35180	1	
36160	1	
36177	1	
36178	1	
36958	1	
36959	1	
36960	1	
36962	1	

ml 09 09 10

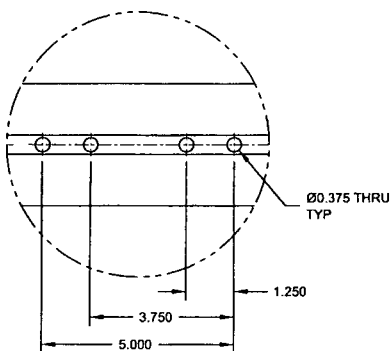
Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

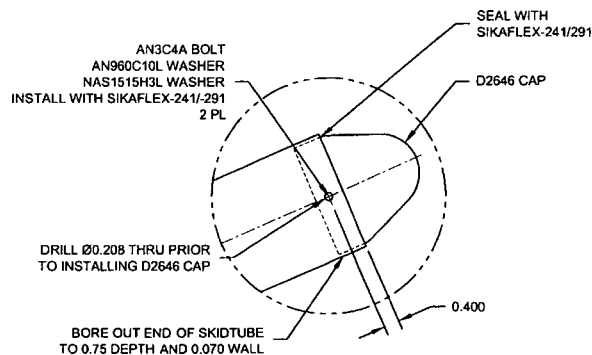
- MATERIAL: N/A
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 20.8 LBS
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291
- WELDING: PER DART QSI 004
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130; IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		

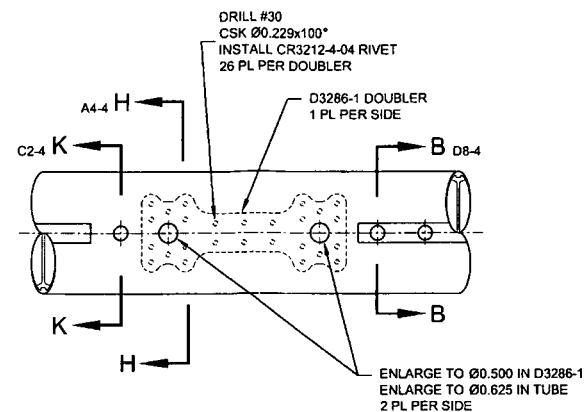
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3288	REV. G SHEET 1 OF 4
TITLE SKIDTUBE ASSEMBLY	SCALE NTS
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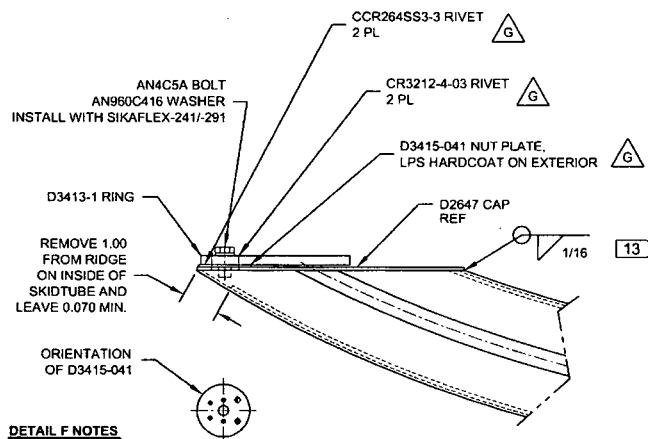
DETAIL A: DRILL DETAIL D6-2, D4-2
SADDLE HOLES, SCALE 5X



DETAIL E B3-2
SCALE 5X



DETAIL G B5-2
SCALE 5X



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QS1 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

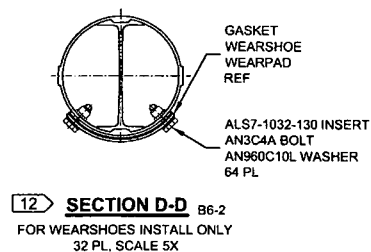
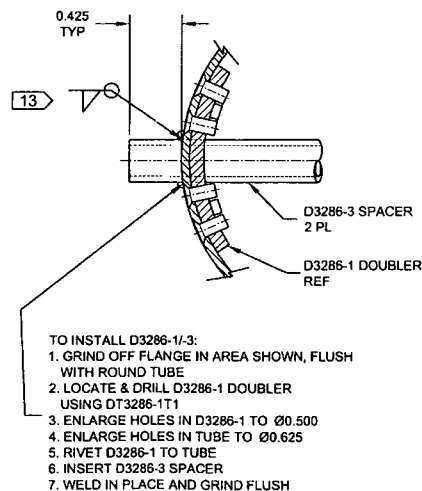
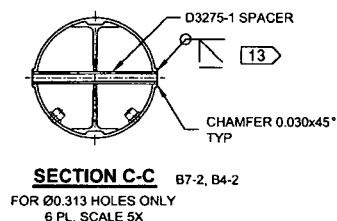
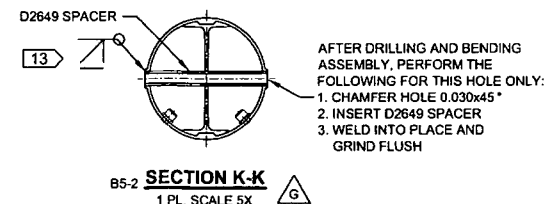
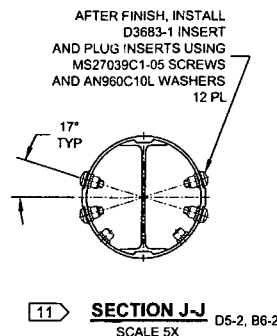
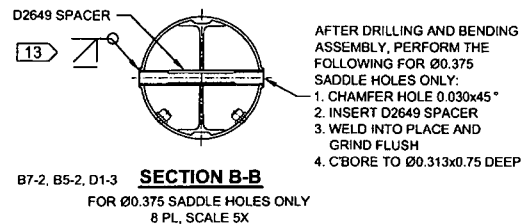
DETAIL F: END FINISHING DETAIL B7-2
SCALE 5X

51855

RELEASED
09/06/17

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



SECTION H-H D3-3
NOT TO SCALE

51855

RELEASED

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	DRAWING NO.	REV. G
MFG. APPR.	99	D3288	SHEET 4 OF 4
APPROVED	99	TITLE	SCALE
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8 7 6 5 4 3 2 1

Date: Thursday, 13/12/2007 10:34:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE RH 206A/B
 Job Number : 32454
 Estimate Number : 10802
 P.O. Number : N/A Part Number : D206642612
 This Issue : 13/12/2007 S.O. No. : N/A Drawing Number : IIN D206-642 REV K
 Prsht Rev. : NC Project Number : N/A
 First Issue : 23/05/2007 Type : LANDING GEAR Drawing Revision : K
 Previous Run : 32453 Material : N/A
 Due Date : 15/06/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:B 05-10-27 Revised pick list KJ/EC
 Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-612 CHG003

08/01/08

2.0 32454A FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW



32454A SP



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

3.0 D206651041 206 A/B GHW Kit



CHG001



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

1 D206651041 GHW Kit Batch: 130235 SP

4.0 D26652 Saddle, RH, Fwd, Aft, Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-2 Saddle 32623 SP

5.0 D26662 Saddle, RH, Fwd, Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-2 Saddle 32625

7/12/13 SP (X)

Date: Thursday, 13/12/2007 10:34:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2652

Bushing

8



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

1535629

SP

7.0

D2712

Set Screw

8



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

1234624

SP

8.0

D2884

Saddle Spacer

8



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer

1535497

SP

9.0

D2885

Saddle Spacer

8



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer

12341782

SP

10.0

D33963

Inventory

8



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer

12341741

1/12/13 50 (IX)

Date: Thursday, 13/12/2007 10:34:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN3C36A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 AN3C36A Bolt M106277 M104541

12.0

MS21250 03004

HIGH STEEL BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

HIGH STEEL BOLT

batch M106277 SP

13.0

D36721

PHENOLIC WASHER



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

PHENOLIC WASHER

batch B34470 SP

14.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt M105426 SP

15.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batc

4 AN5C7A Bolt M19185 SP

16.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt M105634 7/12/13 SP (x)

Date: Thursday, 13/12/2007 10:34:16 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN5C32A

S



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt M105156

18.0

AN5C35A

S



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C35A Bolt M18918

SD

SD

19.0

AN5C13A

S



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

bolt

batch M104999

SD

20.0

AN6C44A

BOLT

S



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN6C44A Bolt M106519

SD

21.0

AN3C41A

BOLT

S



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch M105858

SD

22.0

AN96C10L

washer

S



Comment: Qty.: 30.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

30 AN96C10L Washer M106302

7/12/13 SD (X)

Date: Thursday, 13/12/2007 10:34:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960C416L

WASHER

S



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer

M104736

M105793
M100651 SQ

24.0

AN960C516L

WASHER

S



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer

M103344

SQ

P10 →

25.0

AN960C616

WASHER

S



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt

M19185

SQ

26.0

MS210433

Nut

S



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut

M105792

SQ

27.0

MS210434

Nut

S



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut

M105793

7/12/13 SQ (1x)

Date: Thursday, 13/12/2007 10:34:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5 Nut M105430 *SP*

29.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut M103693 *SP*

30.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch M105792 *SP*

31.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch B36319 AS 08/01/08 *SP*

32.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PHENOLIC WASHER

batch M35522 *SP*

33.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

batch M35521 *SP* *1/12/13* *(12)*

Date: Thursday, 13/12/2007 10:34:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE RH 206A/B

Job Number: 32454

Part Number: D206642612

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

PHENOLIC WASHER

batch M34471

7/12/03 SD (1x)

35.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

SCREW

batch M106524

7/12/03 SD (1x)

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/01/09 (1x)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-612

Location: C

PPP Rev: C

C. S. J. / C. F. (1x)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/09 (1)

Job Completion



08-01-09

B32454A